

# Work Order ID 77623

Wednesday, December 14, 2011 7:19:47 AM

**\*77623\***

Page 1

Item ID: D2600-3-BENT

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Extrusion Bent

Stop **\*NS2\***

Start Date: 12/14/2011 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 12/21/2011 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals: Process Plan: MMF

Date: 11-12-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2600	Rev D1
D2750	F

100

**\*100\***

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

Pick qty 1 D2600-3-120 extrusion

1-Deburr one end of extrusion

2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635

3- cut fwd end of tube as per dwg D2750

4- cut aft end of tube as per dwg D2750

110

**\*110\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

MO / 11-12-14 PTO 15

77623

W/O: 77623		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2600-3-Bent PAR #: \_\_\_\_\_ Fault Category: Landing gear NCR: Yes No DQA: Stop Date: 19/12/2011  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/12/20 Date: 11/12/20

NCR: 11-1081		WORK ORDER NON-CONFORMANCE (NCR) # 1385						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-12-14	100	Guillotine stopper was bent causing tube to be 0.300" to start.  RC; Lack of attention operator error Dumir Stewart	S 11/12/16 057047	Scrap + replace  Re-train employee's to be more Attention	<u>MO</u> 11-12-19	SAD 11-12-19	S 11/12/16 057042	S 11/12/16

NOTE: Date &amp; initial all entries

**Work Order ID 77623**

Wednesday, December 14, 2011 7:19:47 AM

**\*77623\***

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Item ID: D2600-3-BENT

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Extrusion Bent

Start Date: 12/14/2011 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 12/21/2011 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Identify as per dwg & Stock Location: **46**

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

**11-12-14**  
**(15)**

# Picklist Print

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Page 1

Work Order ID: 77623

Parent Item: D2600-3-BENT

Parent Item Name: Extrusion Bent

Start Date: 12/14/2011

Required Date: 12/21/2011

Start Qty: 15.00

Required Qty: 15.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120 Extrusion Round 3" 350		Manufactured	No			100	Each	19.0000	1	15			

### Location

### Loc Qty

### Loc Code

LG

19

66973

19

16

MO

11-12-14



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>+GP</i>	

RELEASED  
98.08.25 DS

### GENERAL NOTES

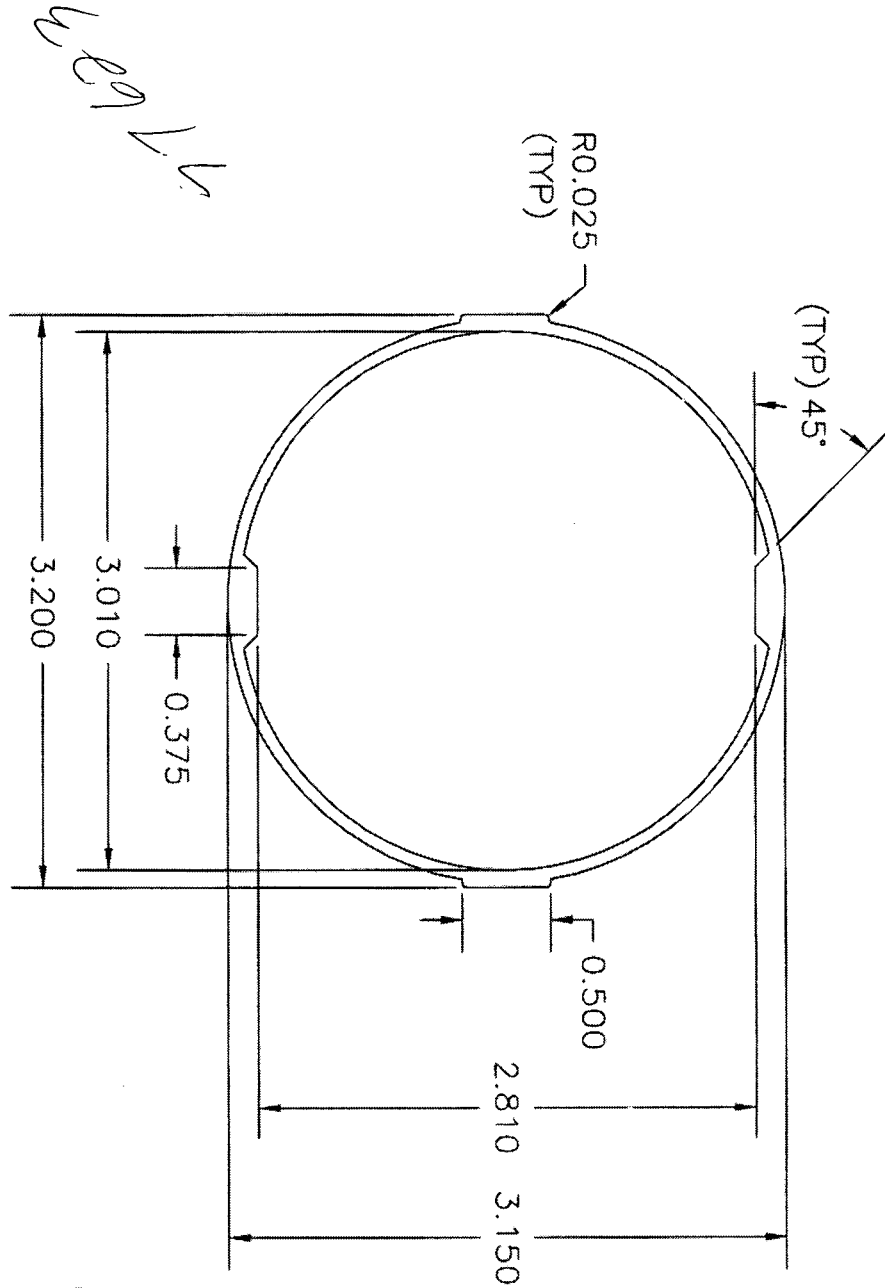
1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

*[Handwritten signature]*  
27023



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870  
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 16" LONG)



RELEASED 98.08.25 DS

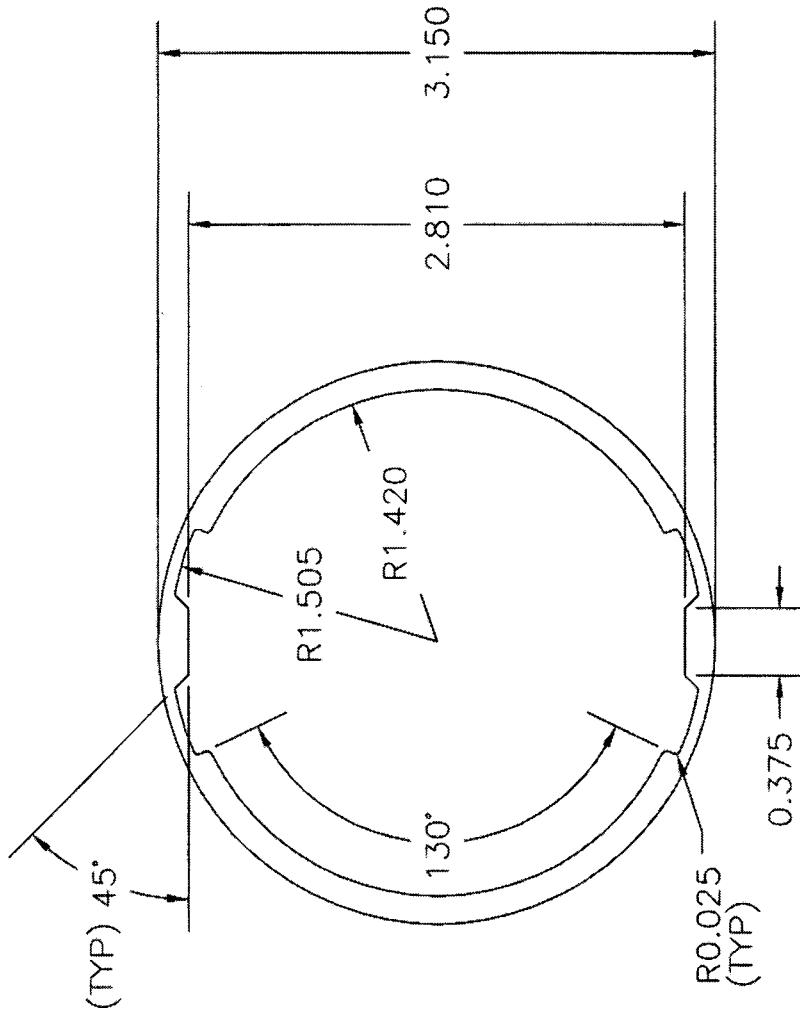
1:1	EXTRUSION	DATE 98.08.20
SCALE	TITLE	DESIGN
SHEET 2 OF 5	REV. D	CHECKED
REV. D	DRAWING NO. D2600	APPROVED
DART AEROSPACE LTD	HAWKESBURY, ONTARIO, CANADA	DRAWN BY





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



\*77623

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

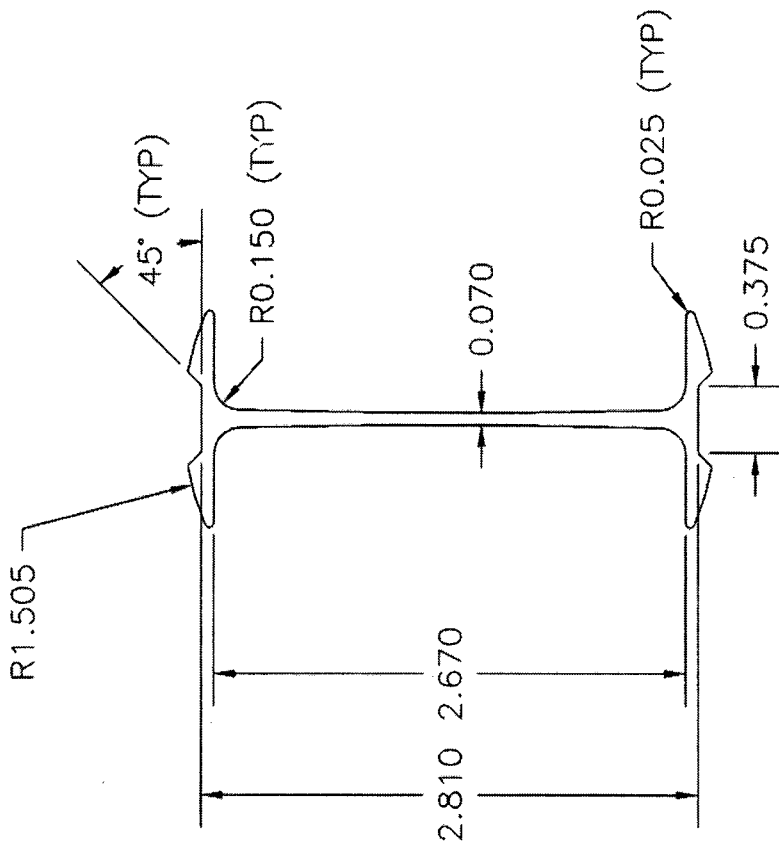
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (Eg. D2600-3-120 IS 120" LONG)





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



*1x T762 1/2*

D2600-5

MANUFACTURED WITH CARADON INDALOX DIE # MS-18871

PART NUMBER IS D2600-S-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-S-108 IS 108" LONG)

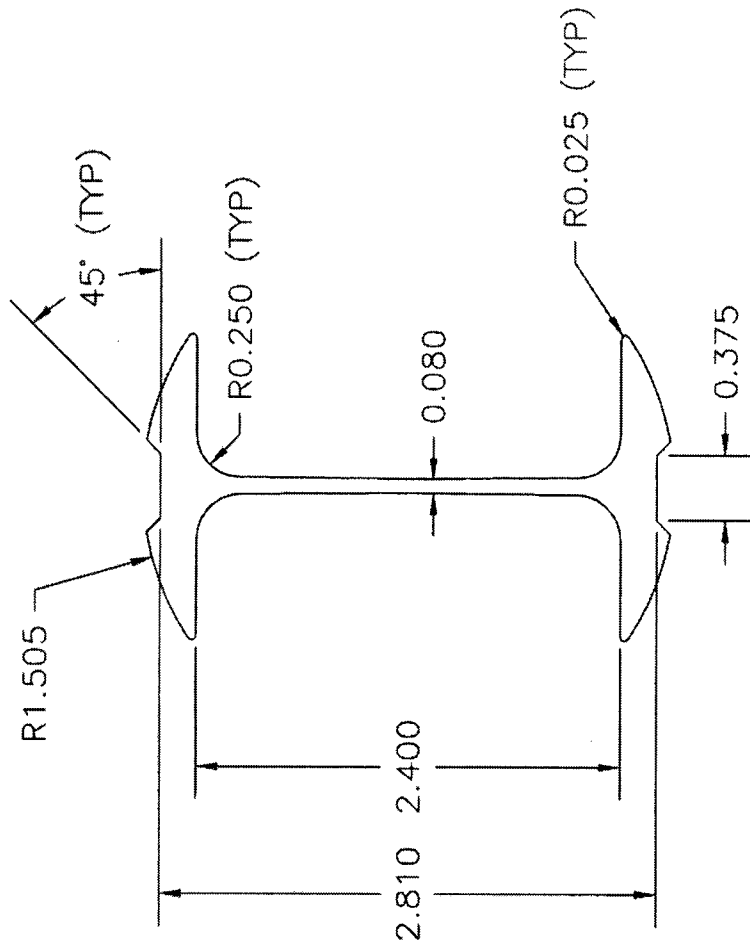






DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



\* 77623

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)

